

## WHAT IS CLAIMED IS:

1. A method of fabricating a piston, the method comprising a step of forging a blank for at least a portion of said piston, the forging step being suitable for chasing an  
5 annular zone of a metal mass while forming a projection that projects from the center of a circular outline base, said projection being shaped and dimensioned so as to be pierced by a bore that is to receive a hinge pin for a connecting rod.
2. A method according to claim 1, wherein said forging also forms two skirt portions  
10 to be formed having substantially cylindrical outside surfaces, and disposed facing each other symmetrically on either side of a hinge-pin direction.
3. A method according to claim 1, wherein said projection is shaped with two substantially plane faces forming an angle between each other so that said projection  
15 flares towards said base.
4. A method according to claim 2, wherein a web is allowed to remain between said projection and the inside wall of each of the above-mentioned skirt portions.
- 20 5. A method according to claim 2, wherein a small column is allowed to remain between said projection and the inside wall of each of said skirt portions.
6. A method according to claim 1, wherein said forging operation is used to form a cavity in the side of said base that is opposite from said projection.  
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7. A method according to claim 1, wherein said blank is formed in a mass of steel.
8. Tooling for forging a blank for at least a portion of a piston, the tooling comprising a hollow anvil having a substantially cylindrical inside wall and a punch including an  
30 open cavity opening out into its end face, said cavity being of a shape and of dimensions that are suitable for defining a projection projecting from the center of a

circular outline base formed at the end wall of said hollow anvil, said projection being for finishing by machining to include a bore suitable for receiving a hinge pin for a connecting rod.

5 9. Tooling according to claim 8, wherein said punch includes two opposite lateral recesses suitable for defining two facing piston skirt portions extending on either side of a hinge-pin direction.

10 10. Tooling according to claim 8, wherein a slot extends between each lateral recess and said cavity in order to define two webs each extending between a skirt portion and said projection.

11. Tooling according to claim 8, wherein the inside wall of said cavity includes indentations for columns.

15 12. Tooling according to claim 8, wherein said cavity includes two substantially plane faces forming an angle between each other so that said projection that results therefrom flares towards said base.

20 13. Tooling according to claim 8, wherein the end wall of said hollow anvil includes a prominence suitable for forming an open cavity in the side of said base that is opposite from the projection of said blank.

25 14. A piston including at least one portion forming a sliding skirt obtained by implementing the method according to claim 1 and also including a central pillar obtained by machining a projection obtained by forging, said pillar including a bore suitable for receiving a hinge pin for a connecting rod.

30 15. A piston according to claim 14, wherein the cylindrical area of the portion of the bore contained between the head of the piston and a longitudinal midplane of the bore

perpendicular to the axis of said piston is greater than the cylindrical area of the other portion of the bore.